Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 34165		
Estimate Number	: 10023		
P.O. Number	: N/A	Part Number	: D205634041
This Issue	: 8/21/2007 S.O. No. : N/A	Drawing Number	: D2580 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 33772A	Material	: N/A
Written By	:	Due Date	: 9/5/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.08.22		

Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002 ① KJ 07-08-25

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B29602

7-8-24

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B33836

AWM 07/09/06

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

8-7-24

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 34165 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

5-Open holes to 0.500" as per Dwg D2580without cutting fluid

6-Countersink holes as per Dwg D2580without cutting fluid

7-Deburr and blow out all chips from inside of tube

7-8-29

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291		M105469

Sikaflex expire date: 08/01/01

Start Time: 12:46 Date: 07/09/06

Fin Time: 10:40 Date: 7-9-7

AWM/DP 07/09/06

5.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-9-7

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes GT 07-09-09

7.0	QC5	INSPECT WORK TO CURRENT STEP

Pins align with all holes

Comment: INSPECT WORK TO CURRENT STEP 07/09/10

8.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	33464

BE 07-09-12

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 34165

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B 33347 BE 07-09-12

Seq. #:	Machine Or Operation:	Description :
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod m105058

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod m105058

BE 07-09-12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending AWM/DP 07/09/13

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64" adjust stopper not to hit web.Deburr

PTO

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes DP 7-9-13

7-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr AWM 07/09/13

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr AWM 07/09/13

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/09/14

Seq. #:	Machine Or Operation:	Description :
12.0	QC5	INSPECT WORK TO CURRENT STEP

07/09/14

Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Appr Chief En Prod Mgr

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 07/09/20

QA: N/C Closed: ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07-09-13	10.0	The aft cap hole was drilled and the bit wandered off to the side "slightly". like this → O R.C: Human error	[signature] QS1042	hole is NOT oversized. Touch-up edge of hole with weld per QS1004, and grind flush.	BE 07-09-14 AW	[signature] 7/09/14	[signature] QS1042	[signature] 07-09-13

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 34165

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 (1X)
	Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI·005	M.. 07/09/17
14.0	POWDER COATING	POWDER COATING M105068 (1X)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	M.. 07/09/17
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	FL 07/09/18 (1)
16.0	D2855	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B29608	BR
17.0	AN35A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: M100188	BR.
18.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M104885	BR
19.0 *	ALS71032130	Insert
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) Insert Batch: M103495	BR.

BR 07-09-19

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 34165 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	AN3C4A	BOLT
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) BOLT Batch: M 105407 BR	
21.0	AN960C10L	washer
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) washer M 105143 BR	
22.0	D356613	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B 32744 BR	
23.0	D35665	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B 33806 BR	
24.0	D35661	GASKET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) GASKET Batch: B 33805 BR	
25.0	D356413	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B 33761 BR	
26.0	D356411	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B 33455 BR	

BR 07-09-19

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 34165
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	D35649	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B 33804 BK

28.0	D35645	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B 32738 BK

29.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: B27168 BK

30.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: B31109 BK

31.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M 105469
Sikaflex expire date: 08-01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R Sikaflex-291 M 105469
Sikaflex expire date: 08-01

BR 07-09-19

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch:
M105386 JJ 07-09-19

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/08/20

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:41:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 34165

Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
32.0	QC5	INSPECT WORK TO CURRENT STEP

EO 07/09/19

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Seq. #:	Machine Or Operation:	Description :
33.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location:________
PPP Rev: H

07/09/19 ①

Seq. #:	Machine Or Operation:	Description :
34.0	QC21	FINAL INSPECTION/W/O RELEASE

①

Comment: FINAL INSPECTION/W/O RELEASE

07/09/20

Job Completion

U 07-09-20

B 34165

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED 07.06.28

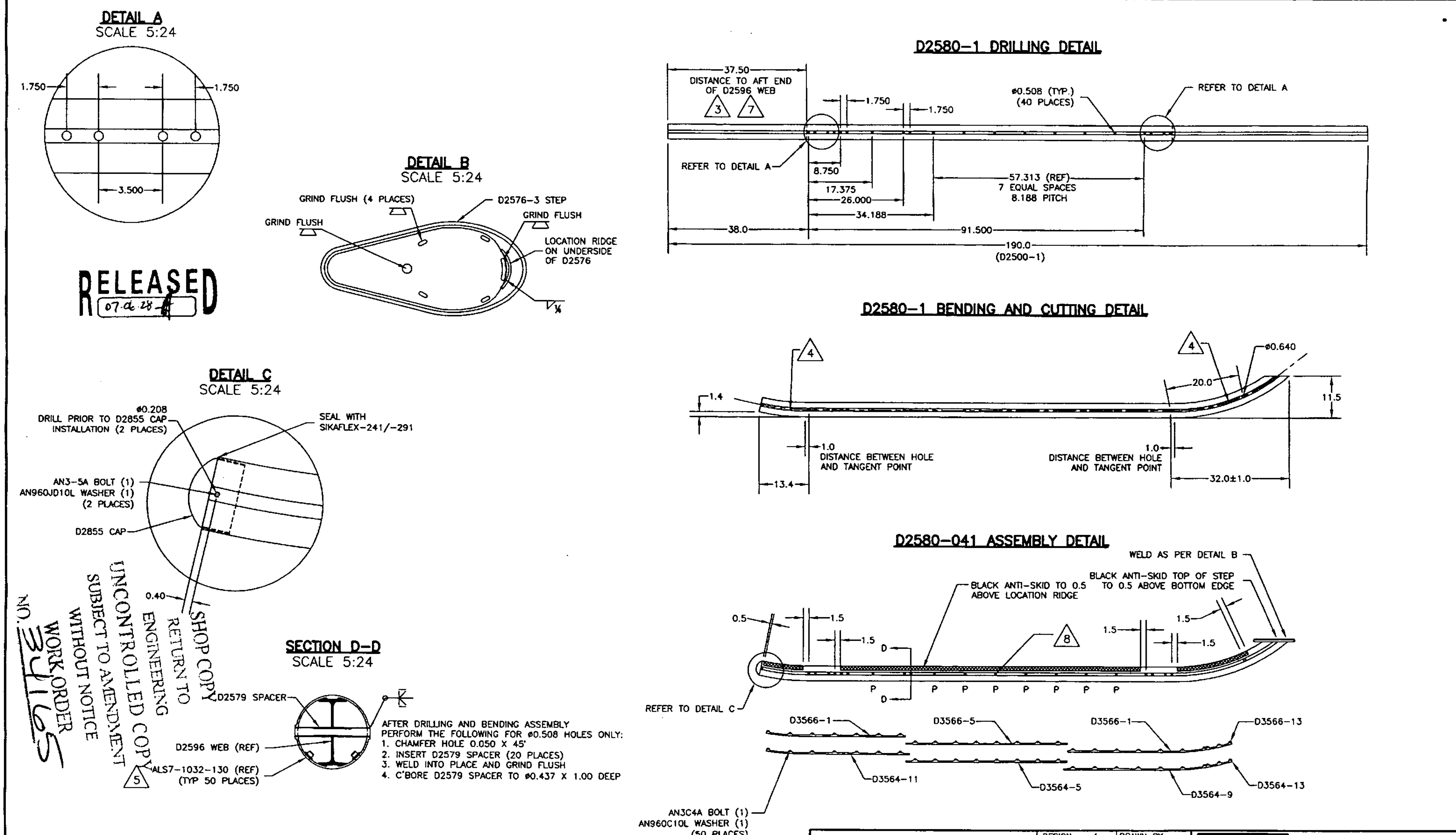
QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 34165

Copyright © 1996 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



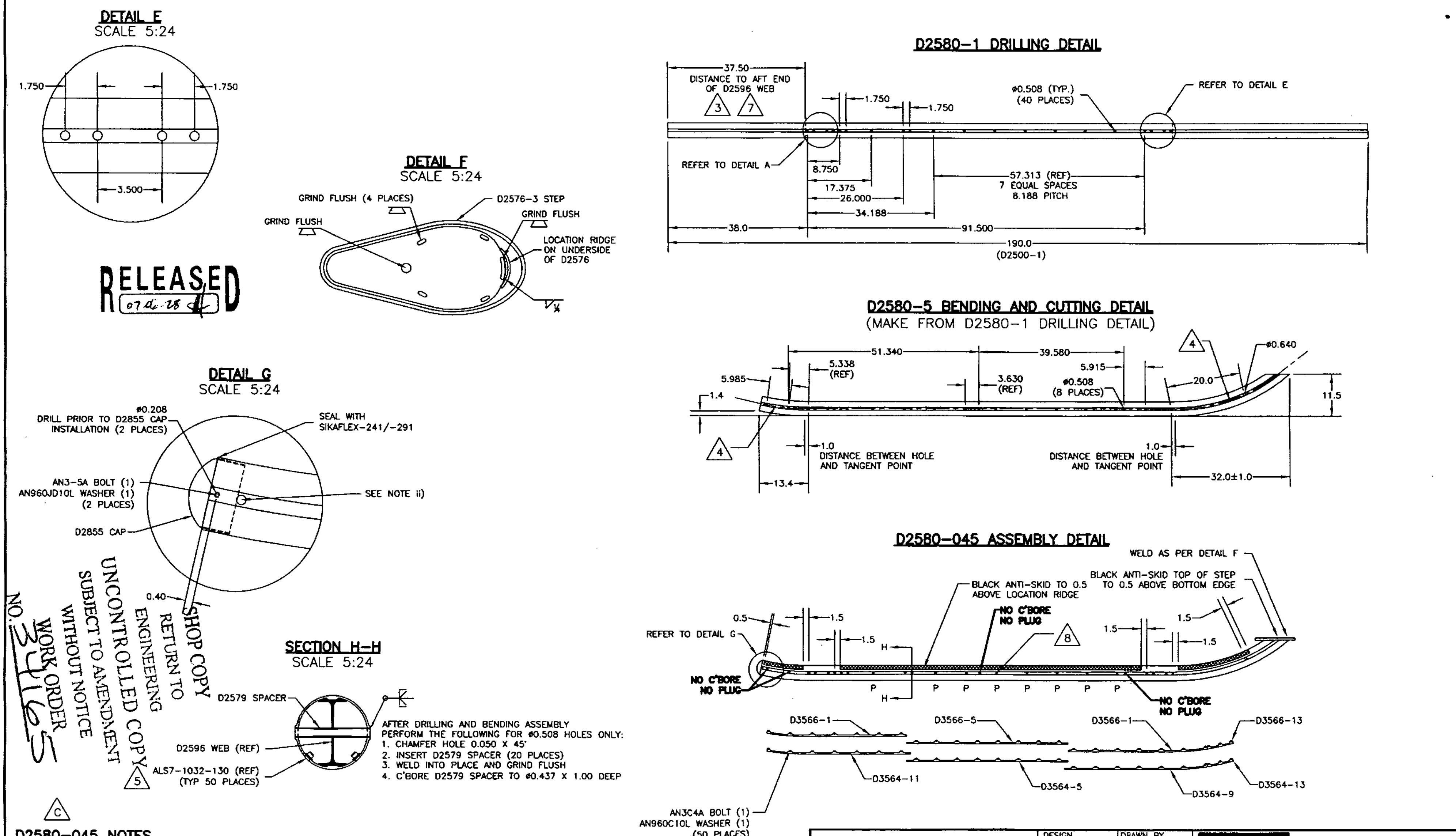
D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24



D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
RH	RH		
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

NO. 126

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay E
Joint Welding Procedure Tig
Part number and Job number D2056340411/B33771 A

TEST WELDS REQUIRED

BASE METAL Alum
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS Tig
Single Weld [✓] Double Weld [ ]
Backing YES [ ] NO [✓]

Position				
			Vertical Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

N/A

Crossbolt Spacer Welded into ______ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/09/05 Qualifier David Duval

H:\FORMS\Production\approved.prod.\Welding Coupon.Rev.A